

Work Order ID 144203-2

Thursday, April 07, 2016 10:41:06 AM

144203

RUSH

Page 1

Item ID: D3564-11

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Aft

Start Date: 4/7/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/12/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: mf

Date: 16-4-7

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3564

D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog

Rev: D 2-Deburr if necessary

(13)

2016/04/07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(13)

2016/04/07

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(13)

DAS
38
9-88

APR 08 2016



Work Order ID 144203

Thursday, April 07, 2016 10:41:06 AM

144203

Page 2

Item ID: D3564-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft
 Start Date: 4/7/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/12/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00			DAS 30 9-89	(13)			APR 11 2016
Brake NC	Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				(13)			DAS 38 9-89 APR 11 2016
Quality Control	Memo	0.00							
150 *150* Large Fab	Large Fab	0.00				(B)			EL 1/64/18
Large Fab	Memo 1- WELD AS PER DWG AND QSI004 2059B HARDCOAT BATCH: M130712	0.00							



Work Order ID 144203

Thursday, April 07, 2016 10:41:06 AM

144203

Page 3

Item ID: D3564-11

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearplate Aft

Stop

NS2

Start Date: 4/7/2016

Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/12/2016

Req'd Qty: 6.00

6

Customer:

Appr. Name:

Appr. Name:

Date:

Appr. Name:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC10- Inspect visual per QSI004- ground welds	0.00							
160									
QC	Memo	0.00				3			DAS 38 9-80
Quality Control									APR 19 2016
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00				3			DAS 38 9-80
Quality Control									APR 19 2016
180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:40. OVEN TEMPERATURE: 320° FINISH TIME: 8:10.					3			38 34 9-80 16-04-19



Work Order ID 144203

Thursday, April 07, 2016 10:41:06 AM

144203

Page 4

Item ID: D3564-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Aft

Start Date: 4/7/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/12/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging	LOCATION : FP002								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.01							
Quality Control									

DAS
38
9-30

APR 19 2016

x3 / all 16/04/19

MJS APR 20 2016

2m 16/04/19

MJS APR 20 2016

1890-1891

1891-1892

1892-1893

1893-1894

1894-1895

1895-1896

1896-1897

1897-1898

1898-1899

Picklist Print

Thursday, April 07, 2016 10:41:04 AM

Page 1

Work Order ID: 144203

144203

Parent Item: D3564-11

D3564-11

Parent Item Name: Wearplate Aft

Start Date: 4/7/2016

Required Date: 4/12/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
 IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
 Verified By: _____

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	262.5090	1.41	8.905263			

M304S16GA

304/316 Sheet .063

16-4-8 JH

Location

Loc Qty

Loc Code

MAT019

166.509

m134067

0.706

m134158

37.803

m134399

64

m134551

64

TPI

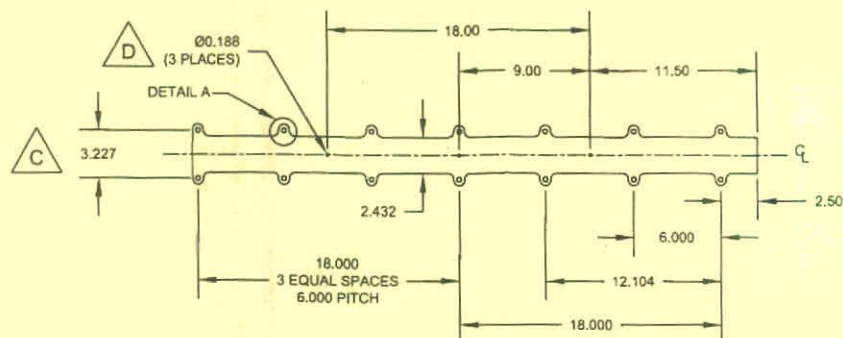
96

m134604

96

14

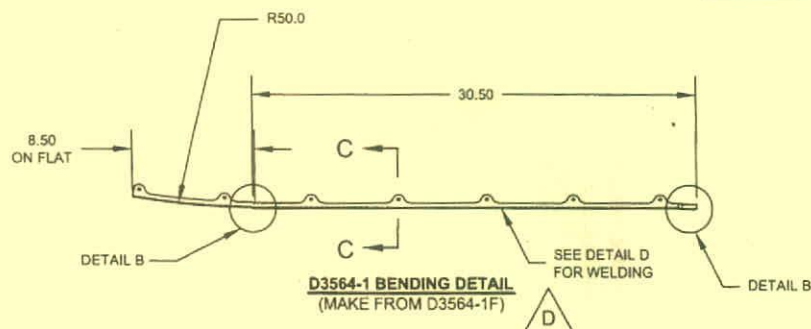




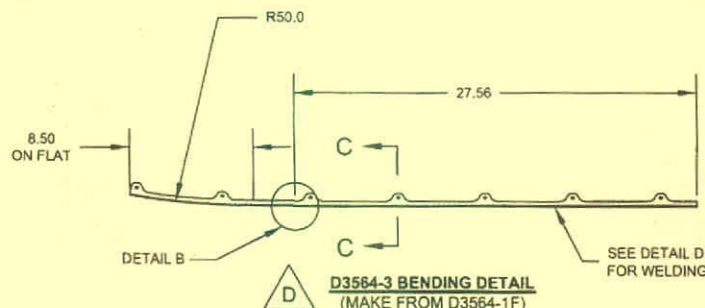
D3564-1F FLAT PATTERN

RELEASED

07.09.04



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW
11/10/04
Twist change
OK 11/11/08

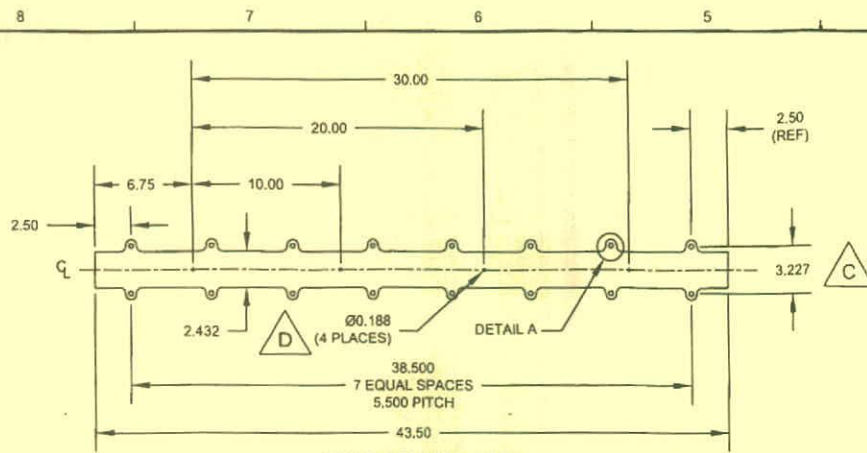
D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

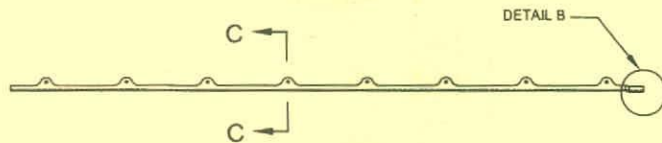
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. D D3564 SHEET 1 OF 3 TITLE SCALE WEARSHOE 1:8 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIALITY IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	CB			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH			
DATE	07.08.21			

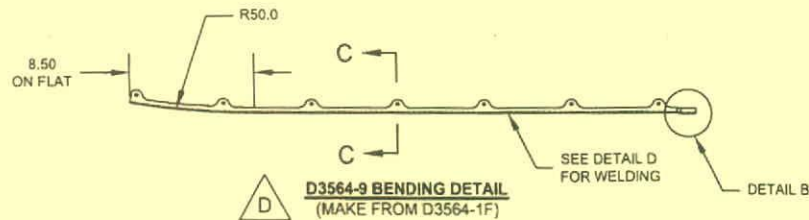




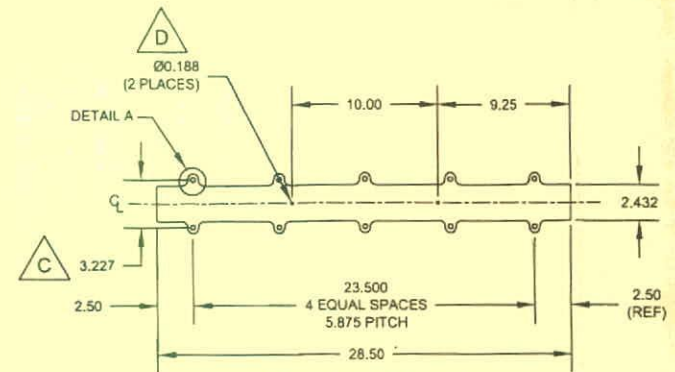
D3564-5F FLAT PATTERN



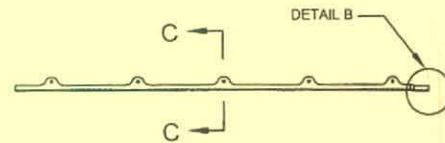
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



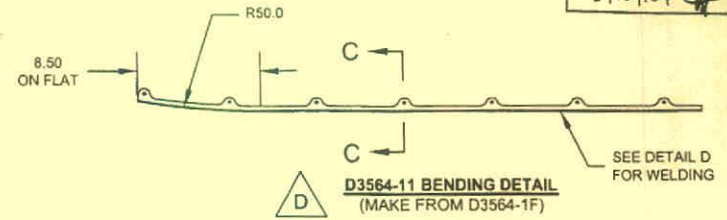
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

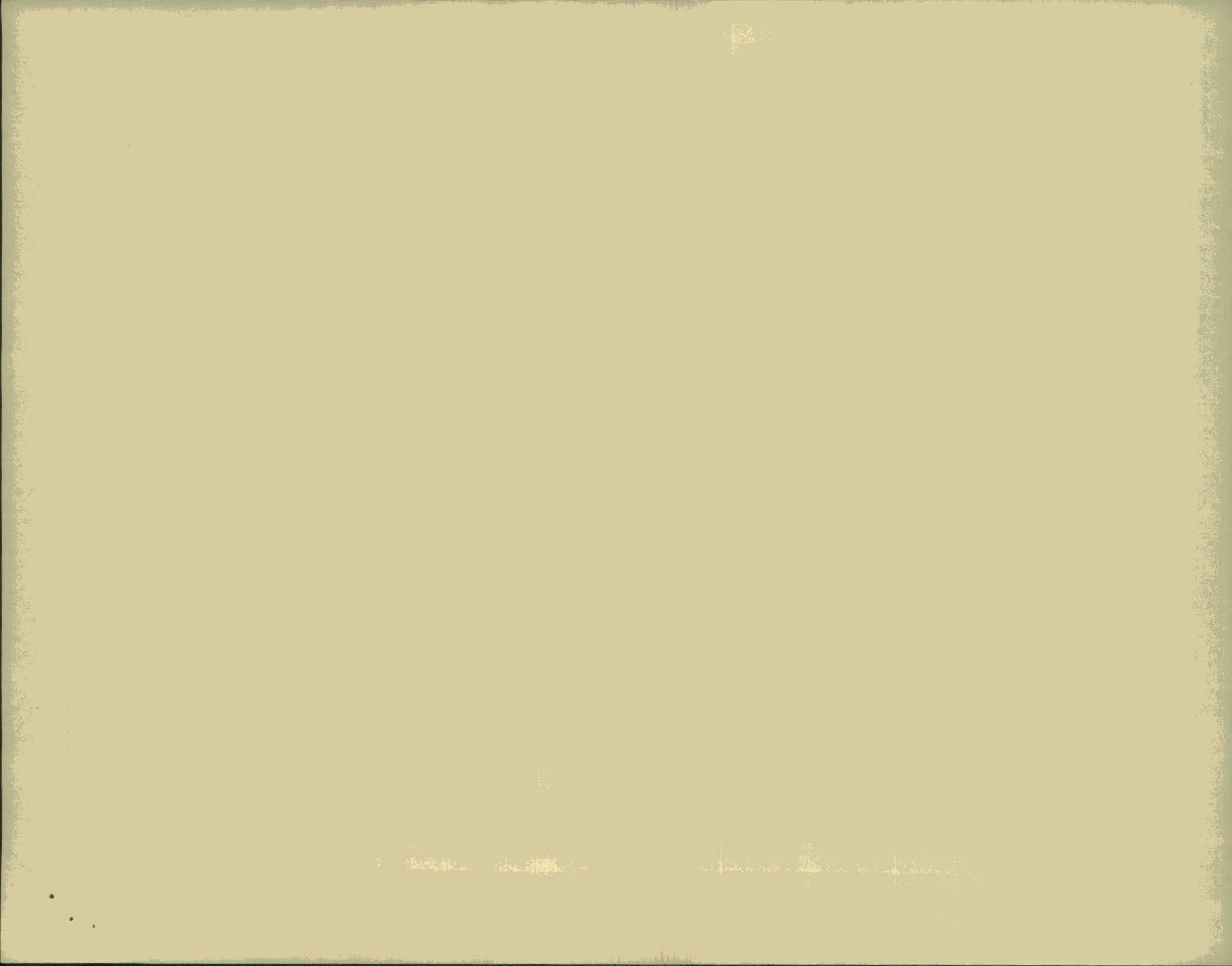


D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

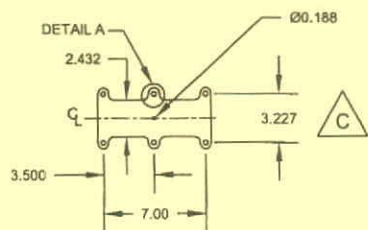
UNDER REVIEW
OK CP 11.11.28

RELEASED
07.09.04

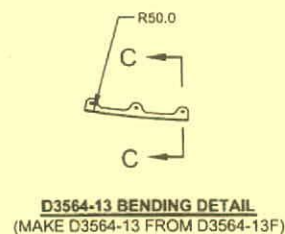
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



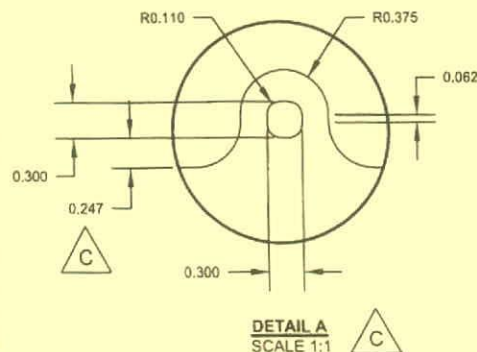
8 7 6 5 4 3 2 1



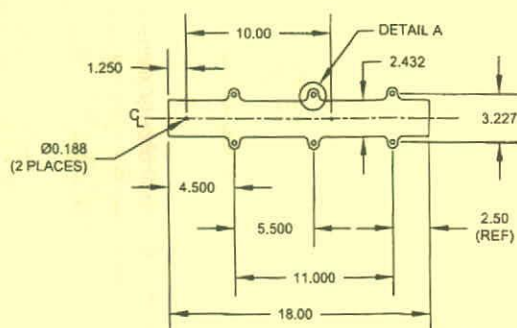
D3564-13F FLAT PATTERN



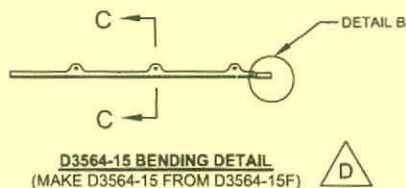
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



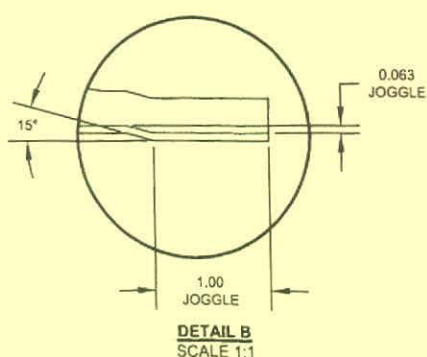
DETAIL A
SCALE 1:1



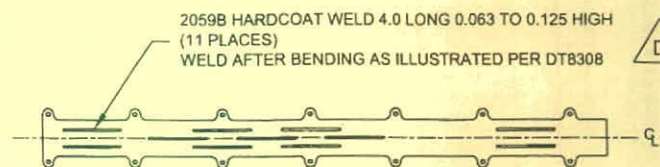
D3564-15F FLAT PATTERN



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL B
SCALE 1:1

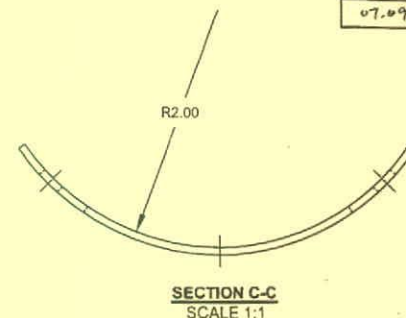


DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

RELEASED

07.09.04



SECTION C-C
SCALE 1:1

UNDER REVIEW

OK 11.11.28

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

